



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D5541-041
Job Sheet 170207

Accounting Job RD17-1027-01



Part No: D5541-041

Job Qty: 12 ea

Part Name: Ground Handling Pin Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 1/11/18

Job Tracking No:

Created By: Mario Poulin

Due Date: 1/18/18

Type: R+D

Description:

Note: DWG D5541 REV A IPP REV:A 17.06.20 NEW ISSUE DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	1/17/18	1/17/18	0.00	0.00	Start Up Machining-4		<i>18/01/31</i>
100	Doosan	12 pcs	1/17/18	1/17/18	0.00	5.49	Doosan		<i>18/01/31</i>
110	QC	12 pcs	1/17/18	1/17/18	0.00	0.00	QC2 Machining-4		<i>18/01/30</i>
120	QC	12 pcs	1/17/18	1/17/18	0.00	0.00	QC8 Machining-4		<i>18/02/05</i>
130	Small Fab	12 pcs	1/18/18	1/18/18	0.00	1.40	Small Fab-5		<i>FF</i>
140	QC	12 pcs	1/18/18	1/18/18	0.00	0.00	QC5		<i>DAS 38</i>
150	Packaging	12 pcs	1/18/18	1/18/18	0.00	0.00	Packaging3-2	<i>5/10/8</i>	<i>DAS 6</i>
160	QC21-SA	12 Ea	1/18/18	1/18/18	0.00	0.00	QC21		<i>9-80</i>

Part Op 100 - 1-Turn as per Folio FB542 Folio Rev: ____ Dwg Rev: ____ 2-Deburr
Descriptions: 130 - INSTALL HELICOIL AS PER DWG

DAS 21
9-80
APR 17 2018
APR 18 2018

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M303R1.000	6	12	0	0
130-Small Fab	MS21209F7-10	12	56	0	0

Fm 137321-40

Part Specifications

Specifications could not be found.

Plex 1/11/18 10:45 AM dart.poulin.mario

DART AEROSPACE LTD		Work Order: 170207
Description: GROUND HANDLING PIN		Part Number: D5541-041
Inspection Dwg: D5541 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0,670	+ 0,000 - 0,002	0,668	✓		MIP-ox	vern
0,472	+ - 0,010	0,472	✓			
0,44	+ - 0,030	0,447	✓			
2,63	+ - 0,030	2,600	✓			
0,500	+ - 0,010	0,505	✓			
0,550/0,600	—	0,570	✓			
0,031 x 45°	+ 0,010 / ± 0,5°	0,030 x 45°	✓			
R 1,00	+ - 0,030	1,002	✓			
0,875	+ - 0,010	0,875	✓			
0,750	+ - 0,010	0,750	✓			
0,031 x 45°	+ 0,010 / ± 0,5°	0,031 x 45°	✓			
R 0,007	+ - 0,010	0,007	✓			
0,500	+ 0,010 - 0,000	0,500	✓			
0,095	+ 0,000 - 0,003	0,093	✓			
3,750	+ 0,005 - 0,000	3,750	✓			
4,345	+ - 0,010	4,347	✓			
7/16-20 HELI	—	7/16-20	✓			

Measured by: DAS 33 9-89	Audited by:	Preliminary Approval:
Date: 18/01/30	Date:	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

DART
AEROSPACE
S037615

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Ground Handling Pin Assembly

PART NO: D5541-041

Original Serial #: S037615

Revision:

Operation: Start up Operation 01/31/18

Change No:

Job No: 170207